

Date: Monday, 08/06/2009 9:24:17 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : MOUNTING LUG
<b>Job Number</b> : 48384	
<b>Estimate Number</b> : 10256	
<b>P.O. Number</b> :	<b>Part Number</b> : D22303
<b>This Issue</b> : 08/06/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2230 REV F
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : F
<b>Previous Run</b> : 47965	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 19/06/2009 <b>Qty:</b> 100 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUD 09.06.08</u>	
<b>Comment</b> : Est D 00.05.18 Added inspection level 8, and removed P/O for powder coat EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D2423	Lug Extrusion
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**Comment:** Qty.: 0.0717 f(s)/Unit Total : 7.1715 f(s)

Lug Extrusion

D2423

Batch: B 43722

09/06/10

1031

2.0	D22303P	LUG
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 100.0000 Each(s)

LUG

09/06/10

1033

3.0	BAND SAW	BAND SAW
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**Comment:** Band Saw

Cut D2423 extrusion to 0.82"

09/06/10

103

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

Machine per folio D2230-3

Check for crack while loading into the machine.

09/06/15

103

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

09/06/15

103

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 08/06/2009 9:24:17 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 48384

Part Number: D22303

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 09/06/15

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- deburr rough edges if necessary

4 09/06/15

(103)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

um 09/06/16

X103

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

START TIME: 12:50pm

OVEN TEMPERATURE: 3209=

FINISH TIME: 1:20pm

9/1 09-06-16 X103

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COATINSPECT POWDER COAT

a.m 09.06.16 (10)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST476

88 09/06/18 X103

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/18

Job Completion



C209/06/18

DART AEROSPACE LTD		Work Order:	48384
Description: Mounting Lug		Part Number:	D2230-3
Inspection Dwg: D2230      Rev: F		Page 1 of 1	

## FIRST ARTICLE INSPECTION CHECKLIST

**X**

## First Article

## Prototype

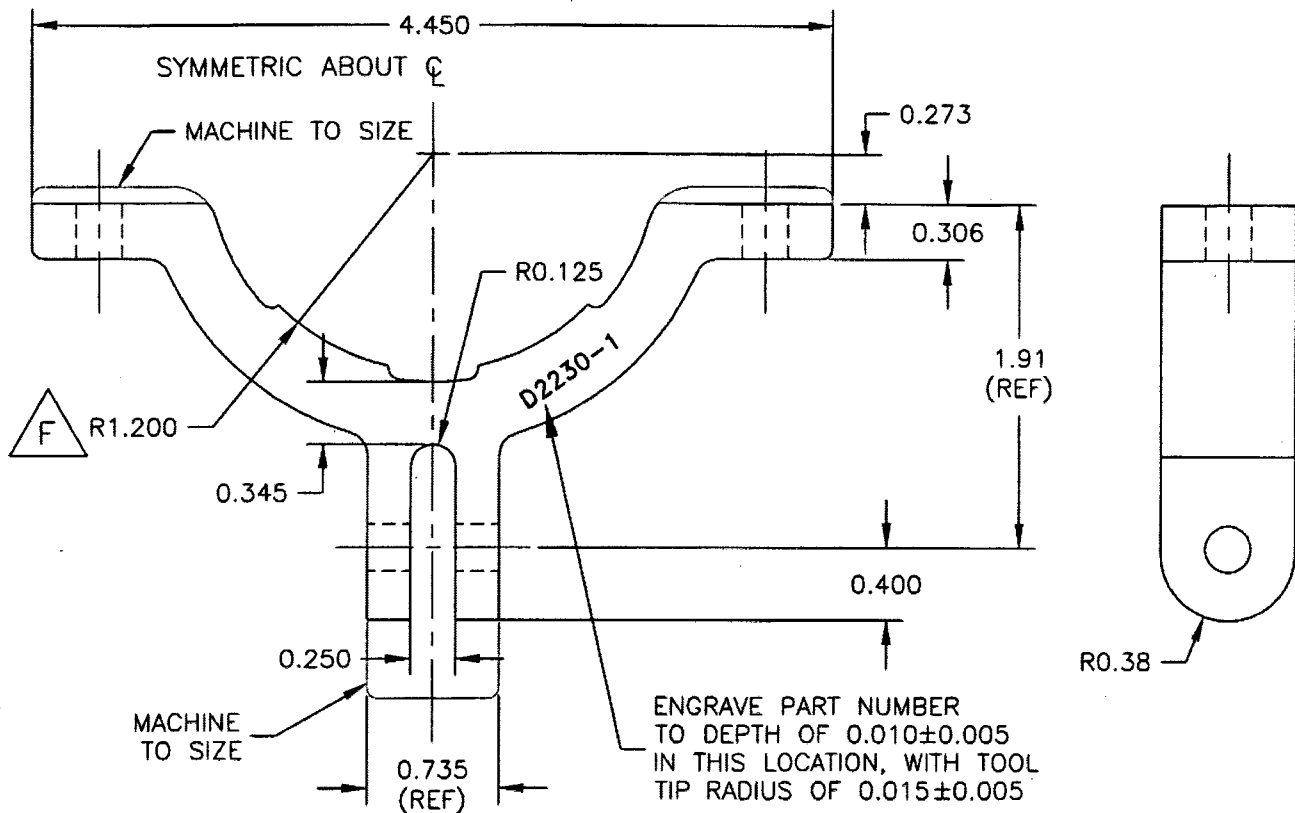
[illegible]

Measured by:	<i>[Signature]</i>	Audited by:	<i>JL</i>	Prototype Approval:	N/A
Date:	09/06/13	Date:	09/06/15	Date:	

Rev	Date	Change	Revised by	Approved
A	03.11.11	New Issue	KJ/RF	[Signature]

**DART**

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D2230	REV. F SHEET 1 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1
C	94.03.30	RE-DESIGN	
D	95.01.04	RE-DESIGN	
E	95.01.04	RE-DESIGN	
F	99.12.13	REDESIGN; R1.200 WAS R1.100	

**RELEASED**  
99.12.21 DS

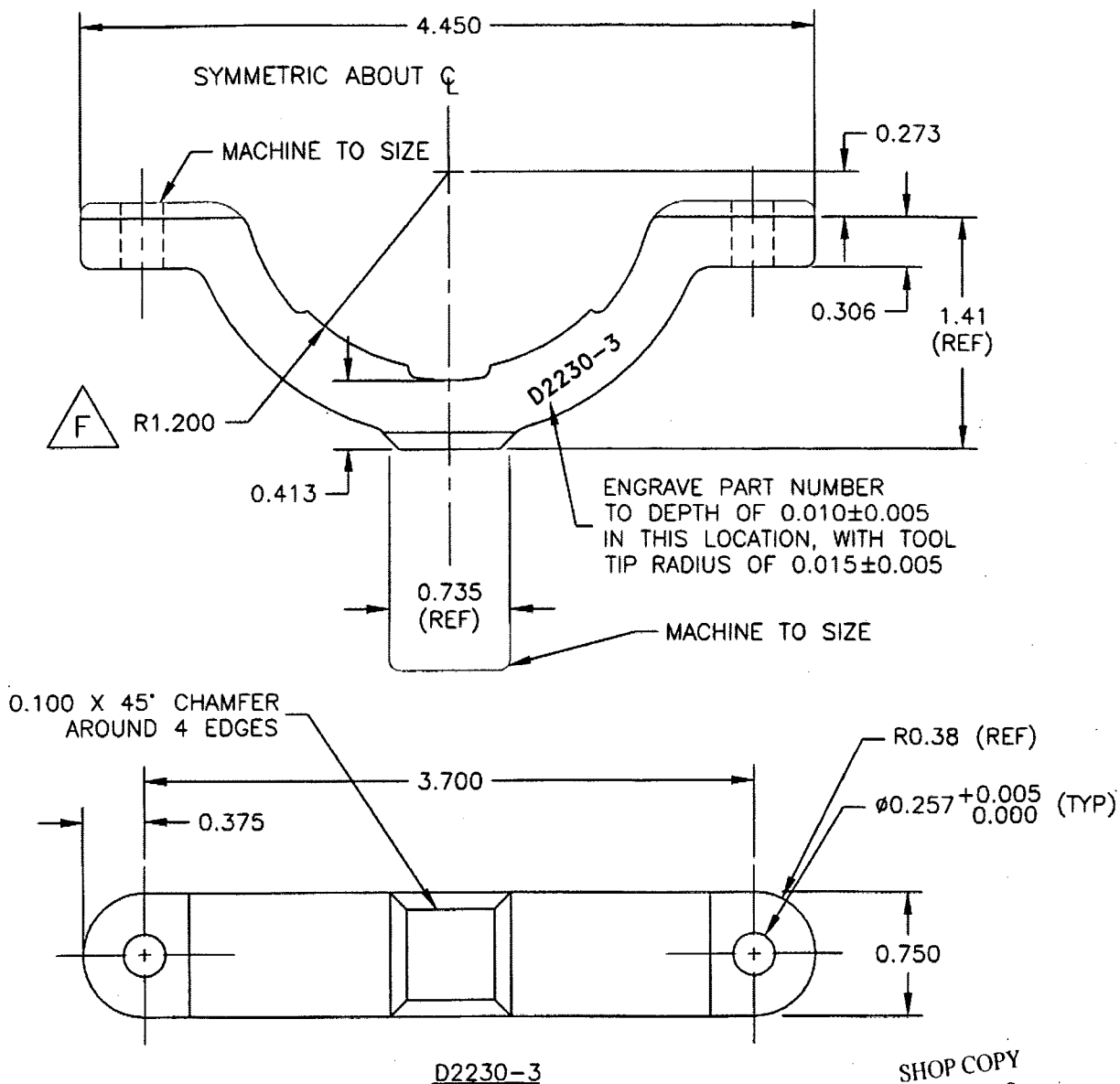
MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3.10  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
48384



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

RELEASED  
79.12.21 DS



MAKE FROM EXTRUSION D2423  
BREAK ALL EDGES 0.000-0.015  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER  
NO. 48384